



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-243
Job Sheet 181008



Part No: D119-646-243

Job Qty: 1 ea

Part Name: AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/10/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG IIN-D119-646 REV D, D3905-045 REV E SHEETS 4,5, 7-14 IPP RevA: New issue DD verified by:EC IPP REV B 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:D 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:E 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:F 17.05.19 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No.	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Skid tubes-1		MBG
110	Skid tubes	1 pcs	8/10/18	8/10/18	0.00	2.07	Skid tubes-1		MBG
120	HandFinish	1 pcs	8/10/18	8/10/18	0.00	1.05	HandFinish1		MBG 18-07-23
130	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC7-1		MBG
150	Skid tubes	1 pcs	8/10/18	8/10/18	0.00	2.07	Skid tubes-1		MBG
155	CNC Bend Skid tubes	1 pcs	8/10/18	8/10/18	0.00	1.20	CNC Bend Skid tube		MBG
165	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		BE
180	Skid tubes	1 pcs	8/10/18	8/10/18	0.00	2.07	Skid tubes-1		MBG
190	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		BE
200	CNC Bend Skid tubes	1 pcs	8/10/18	8/10/18	0.00	1.20	CNC Bend Skid tube		MBG
210	Skid tubes	1 pcs	8/10/18	8/10/18	0.00	1.41	Skid tubes-1		MBG
220	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		BE
224	Skid tubes	1 pcs	8/10/18	8/10/18	0.00	3.70	Skid tubes-1		BE, MBG
225	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		18-08-03
226	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC10		18-08-03
227	HandFinish	1 pcs	8/10/18	8/10/18	0.00	1.05	HandFinish2		SA 18-08-03
240	SprayPaint	1 pcs	8/10/18	8/10/18	0.00	0.56	Spray Paint		18 AUG 03 2018
242	Outsource	1 pcs	8/10/18	8/10/18			ATE003-VC	5	N/A
245	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC14		18-08-03
250	HandFinish	1 pcs	8/10/18	8/10/18	0.00	1.05	HandFinish4		BE 18-08-07
260	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		18-08-07
270	HandFinish	1 pcs	8/10/18	8/10/18	0.00	1.49	HandFinish4		BE 18-08-07
280	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		18-08-08
285	HandFinish	1 pcs	8/10/18	8/10/18	0.00	1.05	HandFinish3		BE 18-08-08
286	QC	1 pcs	8/10/18	8/10/18	0.00	0.00	QC5		18-08-08
288	DC	1 pcs	8/10/18	8/10/18	0.00	0.00	DC		18-08-08
290	Packaging	1 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3-1		18-08-08
300	QC21-FG	1 Ea	8/10/18	8/10/18	0.00	0.00	QC21		18-08-08

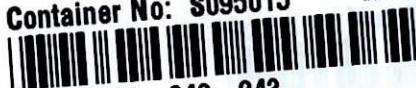
Part Op 110 - 1- Inspect Mat'l D2500-1-190 for damage 2- Ensure squareness of ends
Descriptions: 120 - Chemical Conversion Coat per QSI005 4.1

Plex 7/19/18 10:16 AM dart.white.jesse

DART
AEROSPACE

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Hawkesbury, ON K6A 1K7
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Container No: S095015



Part: D119-646-243

Job No: 181008

Serial No/Batch: S095015

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 15/10/2016, TC STC LoA P-09-0407-RDIMS.

130 - QC7-Inspect Chemical Conversion Coat

150 - 1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Scribe batch # inside aft end of tube

155 - 1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end. 2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

165 - QC5- Inspect part completeness to step on W/O

180 - 1- Verify dimension of bend as per dwg D3905 2- Buff out marks left from bending. 3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, open to finished size 4- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E) ***DO NOT OPEN FWD SADDLE HOLES*** 5- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail G open to finished size 6- Deburr, blow out chips from inside of tube 7- Bond web in place as per Dwg D3905 & QSI 015. A/R Sikaflex-291 138874 Sikaflex expire date: 19-03-06 Start: _____ Time: _____ Finish: _____ Time: _____ ***** (Adhere for 12 hours)*****

190 - QC5- Inspect part completeness to step on W/O

200 - 1- Bend Fwd end of tube using bender 1 and bend prog. D3905 & Folio -04 Fwd. Use bending aid DT9544 ensure proper positioning 2- Cut Fwd end of tube as per dwg. ***VERIFY MEASUREMENT BEFORE CUTTING***

210 - 1- Buff out marks left from bending 2- Drill Fwd cap holes using DT8215. 3- Open Fwd saddle holes to finished size as per dwg 4- Drill Fwd x-bolt hole and open to finished size using DT9816 5- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 6- Drill towing hole using DT10047 locate from FWD saddle hole and open to finished size. 7- C'sink FWD cap hole as per detail "C" 10- Deburr, blow out chips from inside of tube.

220 - QC5- Inspect part completeness to step on W/O

224 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1- Countersink x-bolt holes as per dwg 2- Remove alodine prepare for welding 3- Insert x-bolt spacers 4- Weld x-bolt spacer as per dwg A/R Alum rod Batch: 138834 5- Grind welds flush as per dwg 6- Counter bore x-bolt holes as per dwg 7- Deburr 8- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skid tube batch#.

225 - QC5- Inspect part completeness to step on W/O TEST FIT USING FIXTURE DT10091.

226 - QC10- Inspect visual per QSI004- ground welds

227 - Pressure Wash per QSI005 4.3

240 - Spray Painting per QSI005 4.2 *****AS PER DEO DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 138862 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 138886

245 - QC14- Inspect Spray Paint

250 - Assemble as per dwg 1-Install inserts as per Dwg D3905.

260 - QC5- Inspect part completeness to step on W/O

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 2- install plugs assembly as per dwg. 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 6- Install (2) D5101-041 and (1) D5101-047 as per dwg by using DT10117

280 - QC5- Inspect part completeness to step on W/O

285 - Wing Walk as per dwg QSI005 4.4 Batch _____

286 - QC5- Inspect part completeness to step on W/O

288 - Document Control Photocopy bluefile & type labels per PPP D119-646-243 CHG 005

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	1 Ea (1 ea)	90-Start up Operation	5081201
D3681-1	Spacer	224 8 Ea (8 ea)	90-Start up Operation	5084724
D3903-1	Spacer	224 12 Ea (12 ea)	90-Start up Operation	5084655
D3885-3	Float Web	1 Ea (1 ea)	180-Skidtubes	5096470
D2579	Crossbolt Spacer	2 Ea (2 ea)	224-Skidtubes	5051552
D2855-5	Cap	1 Ea (1 ea)	224-Skidtubes	5066894
ALS4-1032-130	Rivnut	10 Ea (10 ea)	250-HandFinish	5007279
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-HandFinish	5058138
AN3C46A	Bolt	4 Ea (4 ea)	270-HandFinish	5024836
AN3C50A	Bolt	4 Ea (4 ea)	270-HandFinish	5075174
AN3C5A	Bolt	12 Ea (12 ea)	270-HandFinish	9x 5057153/50 852/4x3
AN4C46A	Bolt	3 Ea (3 ea)	270-HandFinish	5006303
D2855-3	Cap	1 Ea (1 ea)	270-HandFinish	5066002
* D3411-3	Washer *	* 16 Ea (16 ea)	270-HandFinish	504997
D3672-1	Washer, Phenolic	2 Ea (2 ea)	270-HandFinish	F150074
D3847-1	Wearpad	1 Ea (1 ea)	270-HandFinish	5054440
D3847-11	Wearpad	1 Ea (1 ea)	270-HandFinish	5026852
D3849-045	Run-on Landing Wearplate Aft For Float Skidtubes	1 Ea (1 ea)	270-HandFinish	5089093
D3849-047	Run-on Landing Wearplate Fwd For Float Skidtubes	1 Ea (1 ea)	270-HandFinish	F154850
D3904-1	Washer	16 Ea (16 ea)	270-HandFinish	5091775
D5101-041	Crossbolt Spacer Assembly	2 Ea (2 ea)	270-HandFinish	F143449
D5101-047	Crossbolt Spacer Assembly	1 Ea (1 ea)	270-HandFinish	5072225
D5101-3	Insert	6 Ea (6 ea)	270-HandFinish	F158939
D5101-5	Insert	6 Ea (6 ea)	270-HandFinish	F158796
MS21043-3	Nut	8 Ea (8 ea)	270-HandFinish	5034415-1x4/5062620
MS21043-4	Nut	3 Ea (3 ea)	270-HandFinish	5089277
MS24694-C52	Screw	2 Ea (2 ea)	270-HandFinish	5067269-1
NAS1149C0332R	Washer	8 Ea (8 ea)	270-HandFinish	5056493
NAS1149D0416J	Washer	3 Ea (3 ea)	270-HandFinish	F1131511

270-004892

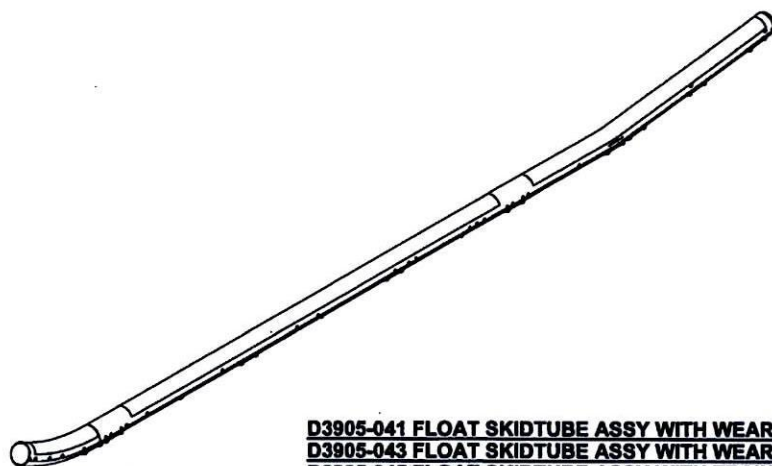
250 - 004878

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	25	0
	D3681-1	8	159	0
	D3903-1	12	154	0
180-Skidtubes	D3885-3	1	2	0
224-Skidtubes	D2579	2	169	0
	D2855-5	1	77	0
250-HandFinish	ALS4-1032-130	10	13,096	0
270-HandFinish	ALS4-1032-225	1	3,869	0
	AN3C46A	4	106	0
	AN3C50A	4	143	0
	AN3C5A	12	1,429	0
	AN4C46A	3	103	0
	D2855-3	1	20	0
	D3411-3	16	24	0
	D3672-1	2	1,018	0
	D3847-1	1	54	0
	D3847-11	1	16	0
	D3849-045	1	4	0
	D3849-047	1	3	0
	D3904-1	16	174	0
	D5101-041	2	10	0
	D5101-047	1	3	0
	D5101-3	6	44	0
	D5101-5	6	30	0
	MS21043-3	8	823	0
	MS21043-4	3	1,646	0
	MS24694-C52	2	175	0
	NAS1149C0332R	8	5,773	0
	NAS1149D0416J	3	2,947	0

Part Specifications
Specifications could not be found.

Plex 7/19/18 10:16 AM dart.white.jesse



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

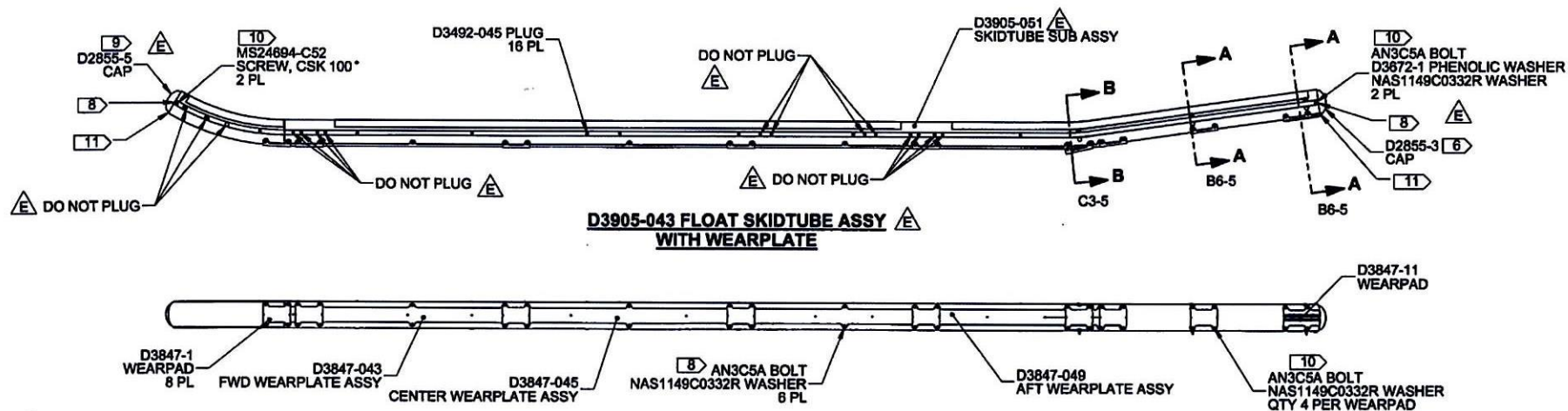
E	COMPLETE REDRAW SEE PREVIOUS REV. AFT FLOAT HOLE NOW Ø0.465 WAS Ø0.437 FINISH REMOVED FROM SADDLE AREA SEE DETAIL F. REF PARTS 421 CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP, REF PART17-553 ADDED DRILL JIG REF NUMBER, NCR15-5306 INCREASE RIDGE RELIEF FROM 0.060 TO 0.130, REF PART17-574	AJS / WK	17.03.13
D	REVISED DIMENSIONS AND PROVIDED TOLERANCE TO SKIDTUBE OVERALL LENGTH PAGE 5-4 REVISED NOTE 2 AND NOTE 7 PAGE 1 (ZN B8, ZN A8-1) REVISED -041/043-045 DRAWING VIEWS, REVISED SECTION VIEW F-F (ZN B4-7), REVISED BOM REF. PART13-206 AND PART13-272	AK	14.06.06
C	(SHT 1 PL, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 46, ADD ITEM 49, MS24884-522 WAS ANSCSA, D3672-1 AND NAS1149C0332R, (ZN C7-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C2-7, D6-7)	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A8-5, A5-6, C5-7, C5-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2855 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); ANSCSA WAS ANSCSA (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD ANSC50A (ZN B3-4); Ø0.313 WAS Ø0.326 (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE W (ZN A8-7)	RF	06.06.30
A	NEW ISSUE	RF	06.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	17.03.13	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
 2017-05-08
 EN 17-519

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3905-043	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-049	AFT WEARPLATE ASSY
8	8	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3905-051	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSSBOLT SPACER ASSY
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -043	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	44	AN3C5A	BOLT
17	3	AN4C46A	BOLT
18	3	MS21043-4	NUT, SELF-LOCKING
19	2	MS24694-C52	SCREW, CSK 100°
20	44	NAS1149C0332R	WASHER
21	6	NAS1149C0416R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 42.8 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\varnothing 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR AKS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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2017-05-08

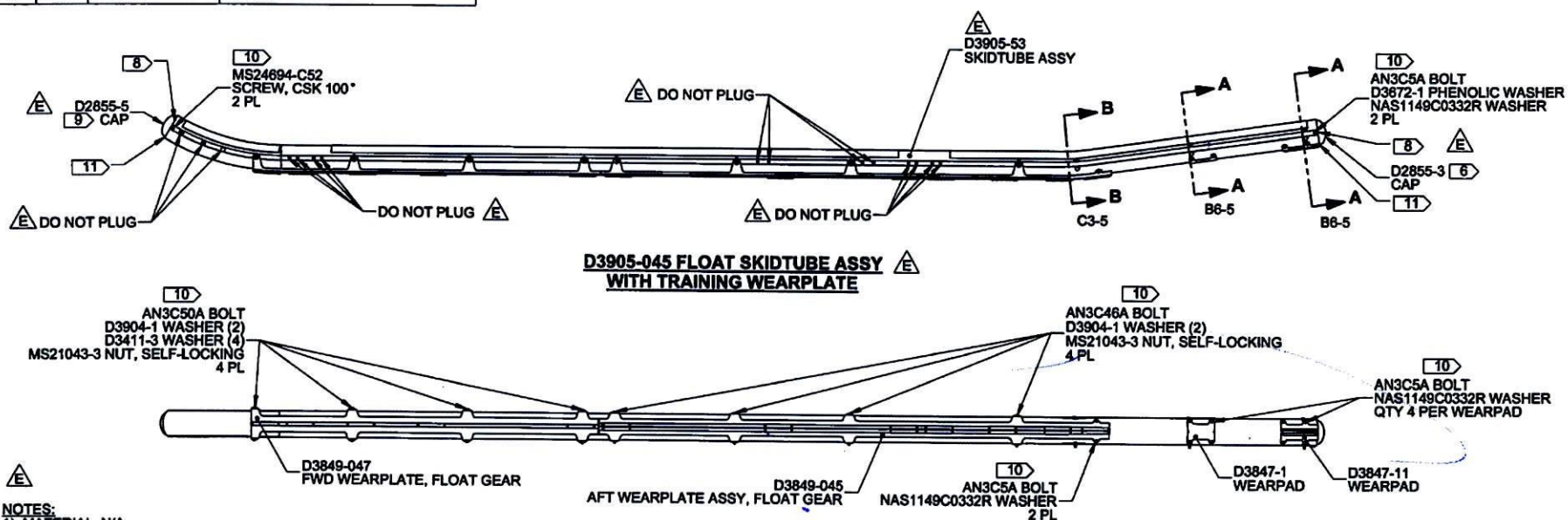
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DESIGN		AJS		DART AEROSPACE USA, INC.	
DRAWN		WK		EUGENE, OR	
CHECKED		VS		DRAWING NO.	
MFG. APPR.		DD		D3905	
APPROVED		HS		TITLE	
DE APPR.		DS		A119 FLOAT SKIDTUBE ASSY	
DATE		17.03.13		REV. E	
				SHEET 3 OF 14	
				SCALE	
				NTS	

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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-045	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3411-3	WASHER
4	2	D3872-1	PHENOLIC WASHER
5	1	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
8	1	D3849-047	FWD WEARPLATE, FLOAT GEAR
9	16	D3904-1	WASHER
10	1	D3905-053	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSS BOLT SPACER
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	12	AN3C5A	BOLT
17	4	AN3C46A	BOLT
18	4	AN3C50A	BOLT
19	3	AN4C46A	BOLT
20	8	MS21043-3	NUT, SELF-LOCKING
21	3	MS21043-4	NUT, SELF-LOCKING
22	2	MS24694-C52	SCREW, CSK 100°
15	12	NAS1149C0332R	WASHER
24	6	NAS1149D0416J	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 48.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY. ALODINE BARE MATERIAL
- 9) USE D3905-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

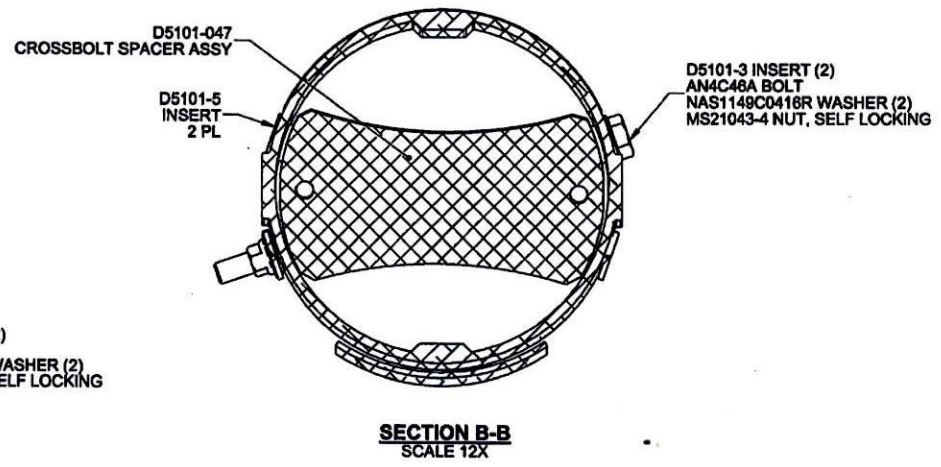
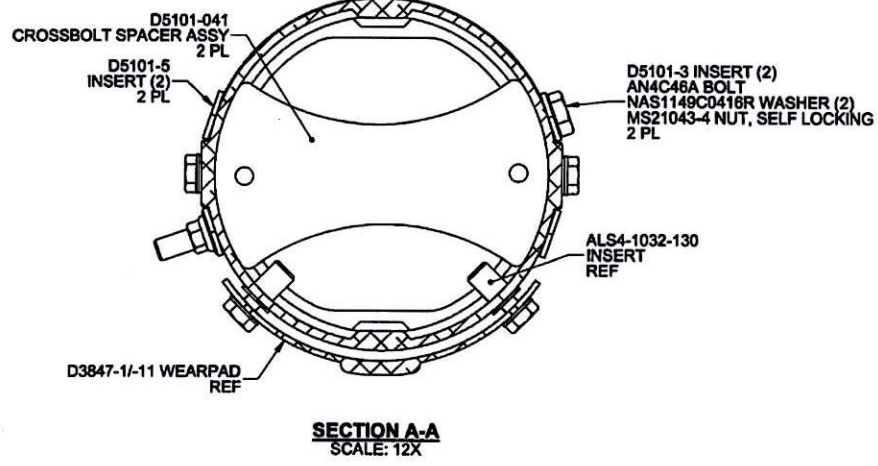
RELEASED
2017-05-08

APPROVED

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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8 7 6 5 4 3 2 1

D
C
B
A



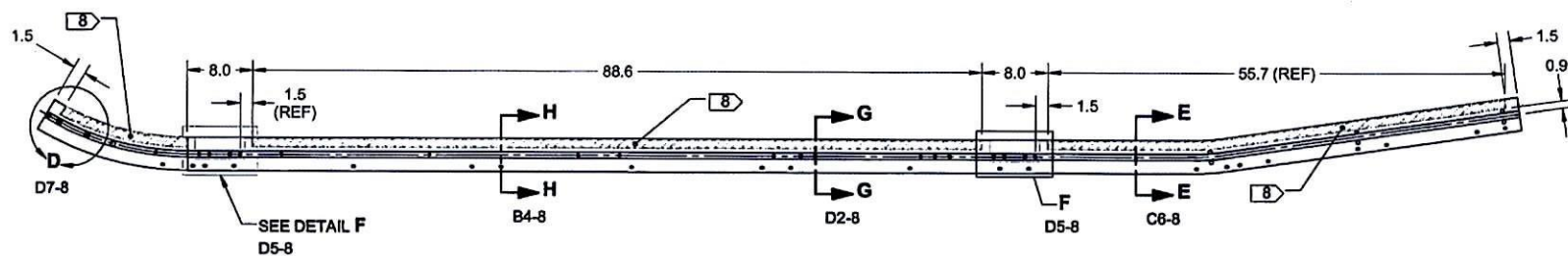
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-061	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

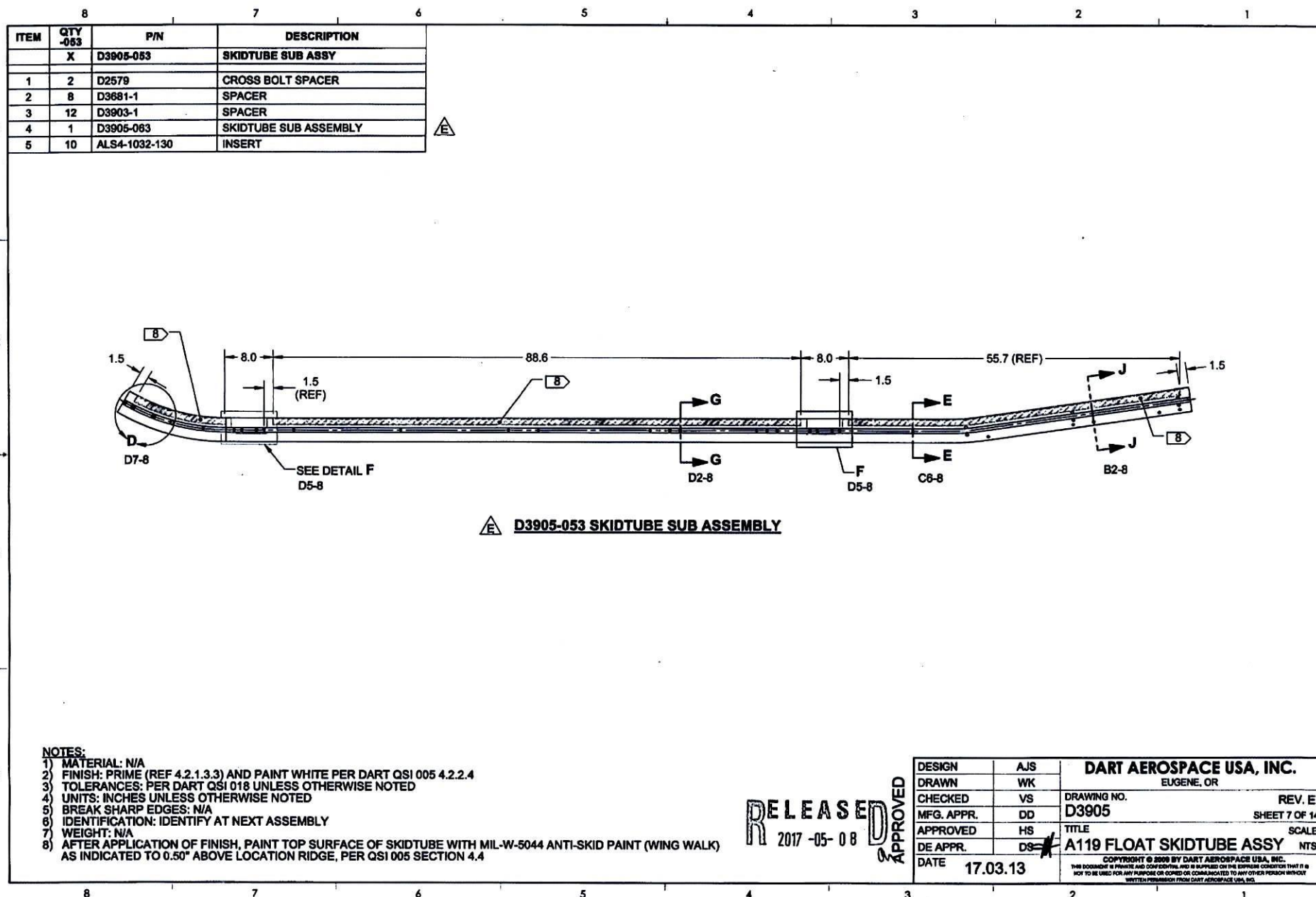
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

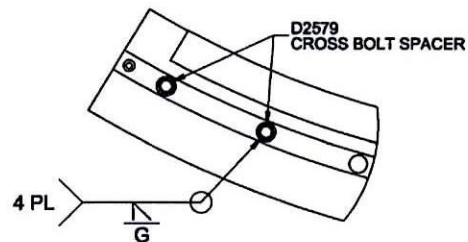
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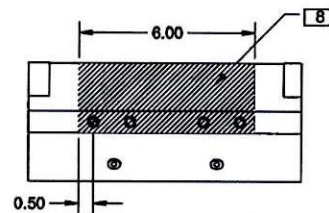
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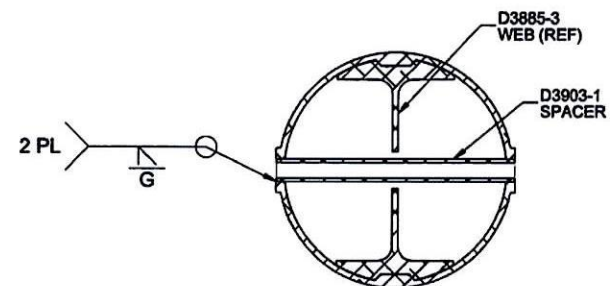
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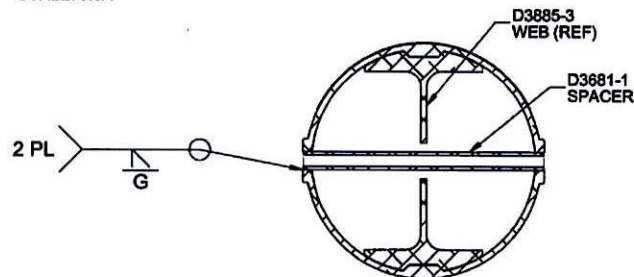
DETAIL D
SCALE: 3.5X



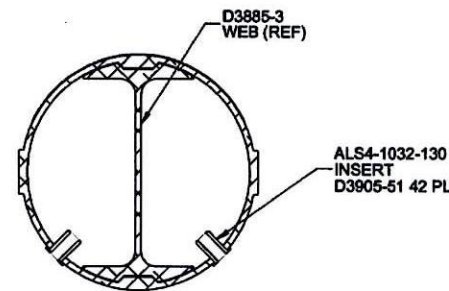
DETAIL F
SCALE: 3.5X



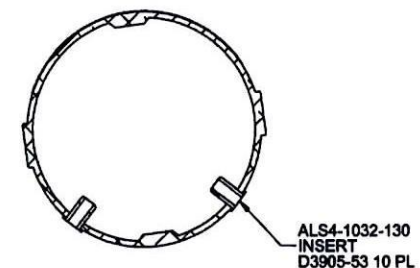
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
8 PL



SECTION H-H
SCALE: 7X
D3905-51 21 PL



SECTION J-J
SCALE: 7X
D3905-53 5 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) CBORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3881-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

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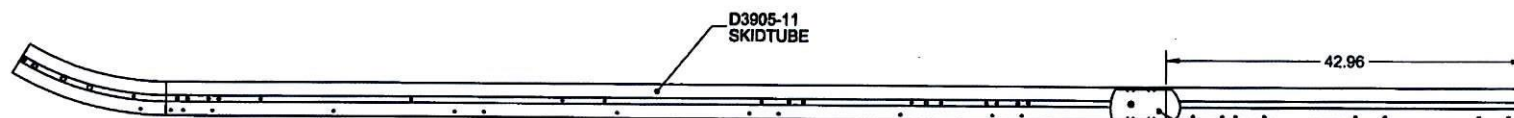
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SHEET 8 OF 14
TITLE **A119 FLOAT SKIDTUBE ASSY** SCALE NTS

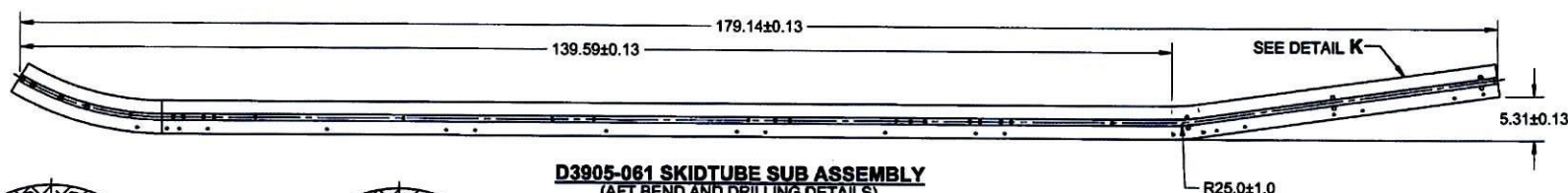
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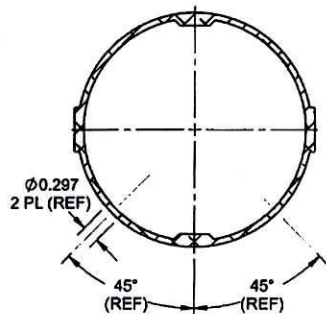
ITEM	QTY -061	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



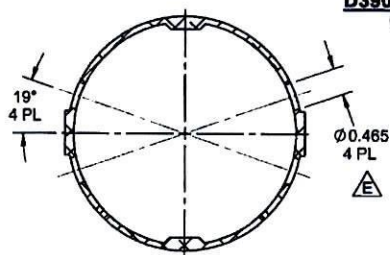
D3905-061 SKIDTUBE SUB ASSEMBLY
(WEB/TUBE ASSEMBLY PRIOR TO AFT BEND)



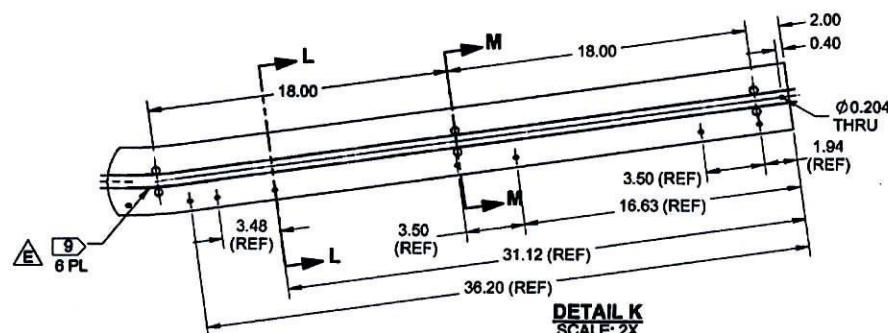
D3905-061 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION L-L
7 PL
SCALE: 7X



SECTION M-M
3 PL
SCALE: 7X



DETAIL K
SCALE: 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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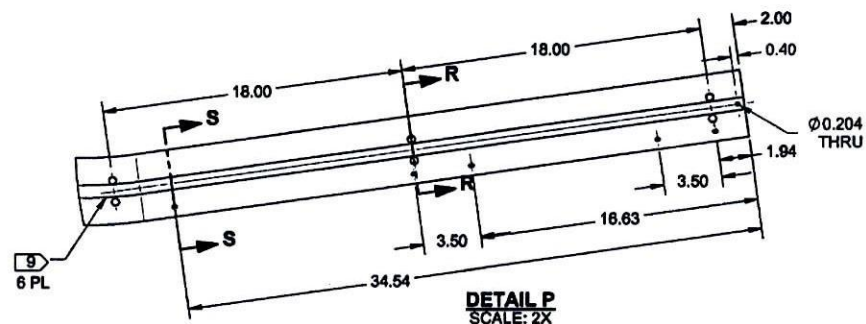
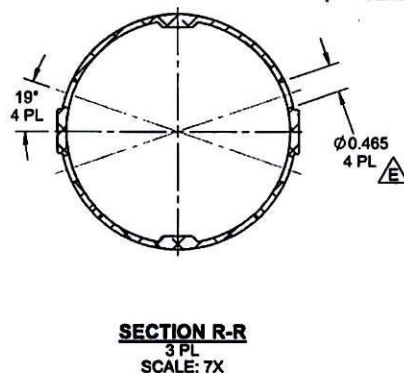
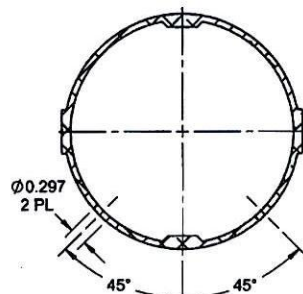
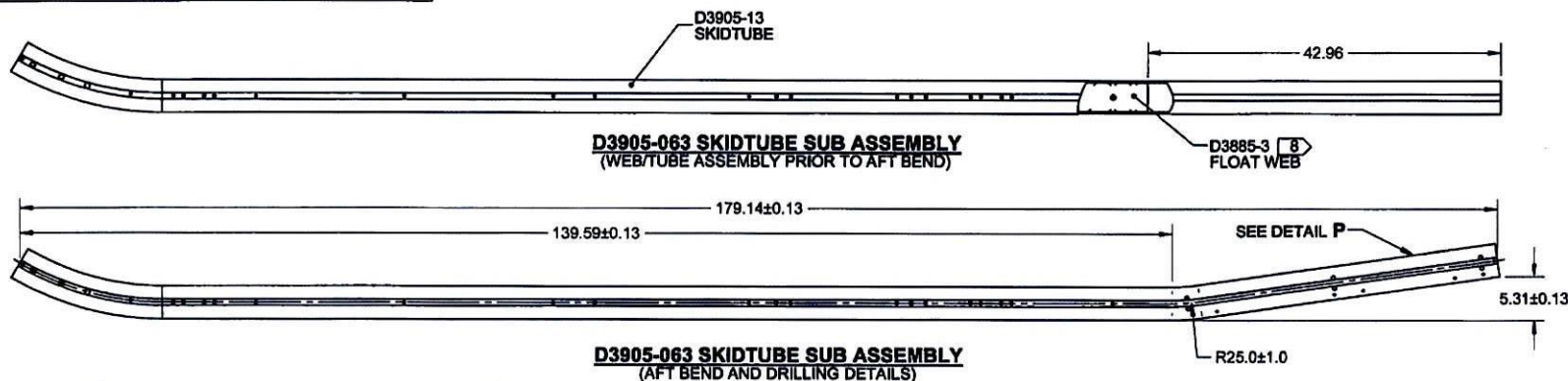
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D3905	SHEET 9 OF 14
TITLE	SCALE
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ITEM	QTY -063	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



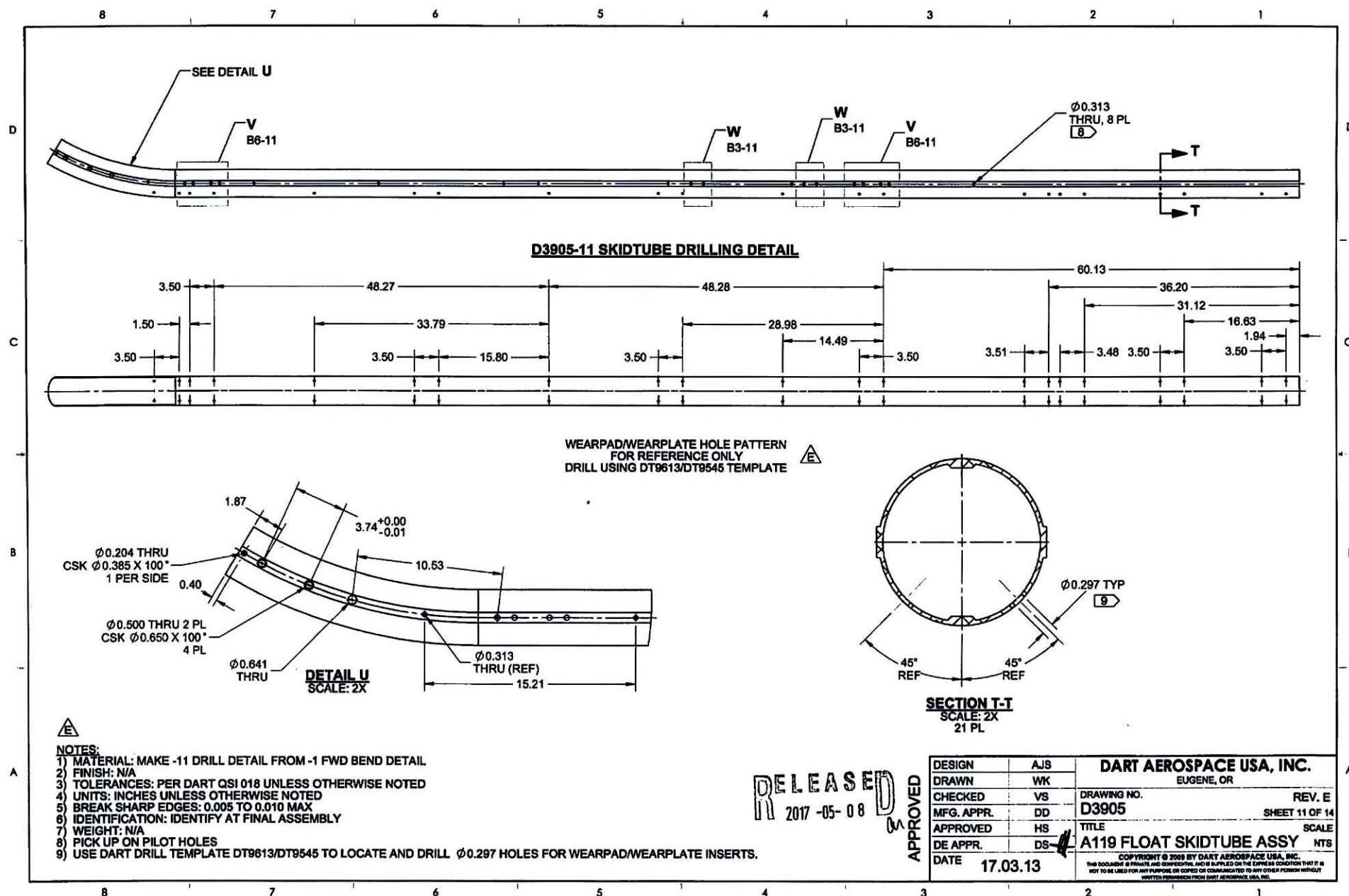
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSTERT CLEARANCE, MAX 0.130 INTO RIDGE

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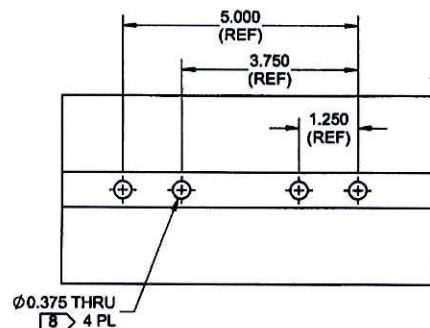
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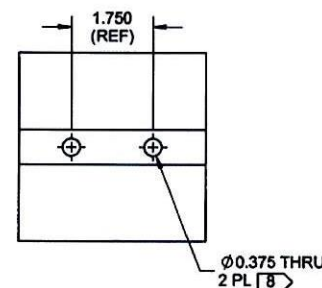


D3905-13 SKIDTUBE DRILLING DETAIL

Ø0.313
THRU, 8 PL
8



DETAIL V
SCALE 4X
2 PL



DETAIL W
SCALE 4X
2 PL

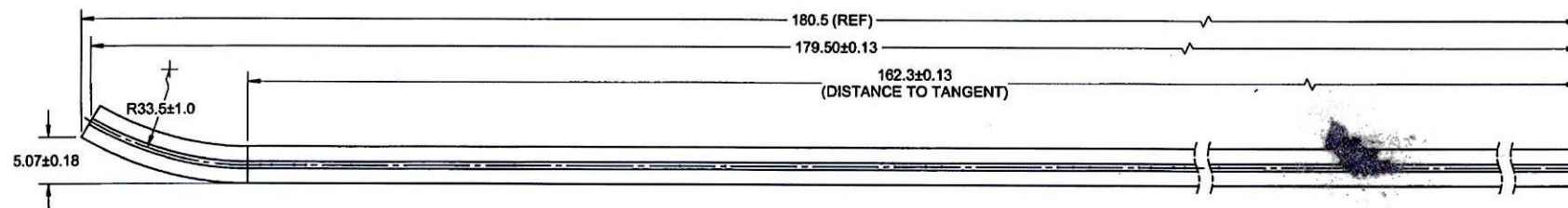
NOTES:

- 1) MATERIAL: MAKE -13 DRILL DETAIL FROM -1 FWD BEND DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) PICK UP ON PILOT HOLES

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D3905-1 SKIDTUBE FWD BEND DETAIL

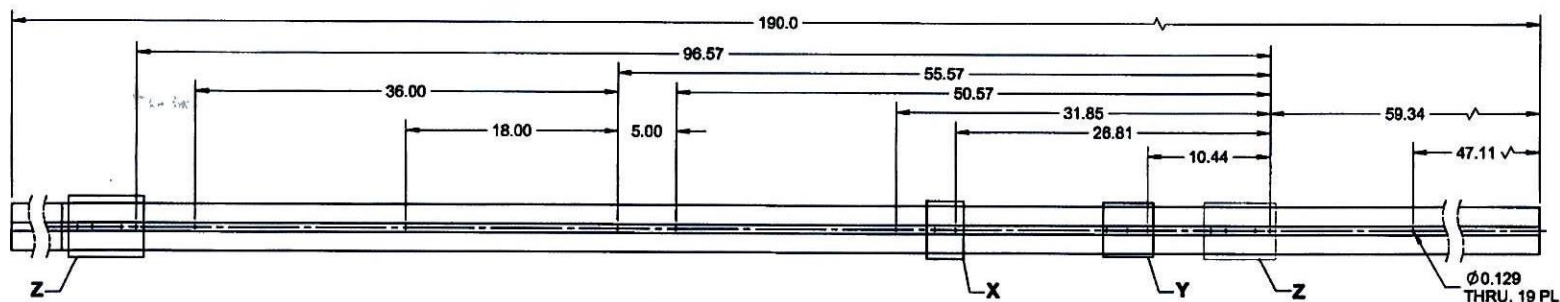
NOTES:

- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

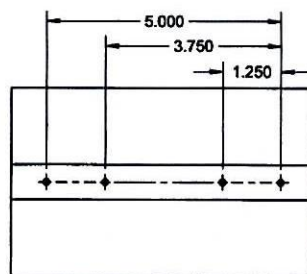
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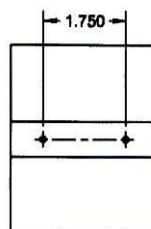
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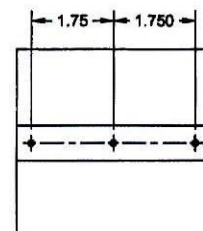
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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TITLE **A119 FLOAT SKIDTUBE ASSY** SCALE NTS

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